Insp.

November 24, 2009 11:15:39 AM D2873-045 Accept Setup Start Item ID: **Revision ID:** Α Stop Item Name: Nut Plate Assembly Cust Item ID: **Start Date:** 25/11/2009 Start Qty: 20.00 **Required Date: 07/12/2009** Req'd Qty: 20.00 **Customer:** Reference: Start Run Date: 7/1-24 Tooling: Process Plan: Date: Approvals: Stop Date:____ Date: SPC (Y/N): QC: Plan Reject Reject Draw Accept Sequence ID/ Operation Set Up/ Draw Qty Qty Number Stamp Code Work Center ID Description **Run Hours** Number Rev. Draw Nbr **Revision Nbr** D2873 Rev A 0.00 100 **BAND SAW** Bandsaw Memo Cut blanks: 1.000" x 0.375" x 2.700" long Jeaspa Bandsaw 0.00 110 HAAS CNC VERTICAL MACHINING #1 0.00 HAAS 1 Memo HAAS CNC vertical machine #1 0.00 QC2- Inspect parts off machine FAI/FAIB 120

Memo

Quality Control

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W/O:	Т		wc	ORK ORDER CHANG	iES		-	,		
DATE	STEP	PR	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspect
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Part No	:	PAR #:	Fault Cate	jory:	_ NCF	R: Yes	No DQ	\ :	Date:	
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NCR:			WORK ORDE	ER NON-CONFORM	ANCE	(NCR)	···		
DATE	STEP	Description of NC	Corrective Action Section				Verific	ation	Approval	Approva
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspect
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Work Order ID 53967

Α



Page 2

November 24, 2009 11:15:40 AM

Required Date: 07/12/2009

Item ID: **Revision ID:** D2873-045

Accept

Setup Start



Stop

Item Name: Start Date:

25/11/2009

Nut Plate Assembly

Start Oty: 20.00

Rea'd Otv: 20.00



Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan: Date:

Tooling:

Date:

Run

Start

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Sequence ID/ Work Center ID

130

Ouality Control

Operation Description

OC8- Inspect parts - second check

Memo

Plan Draw Rev. Code

Accept Oty

Reject Qty

Reject Insp. Number Stamp

140

Small Fab

Small Fab

Memo

Memo

0.00

Small Fab

1-Deburr □2- C'sink as per Dwg D2873

0.00

150

Quality Control

OC5- Inspect part completeness to step on W/O

2) Sozlulza

Dart Aerospace Ltd W/O: **WORK ORDER CHANGES** Approval Approval DATE STEP PROCEDURE CHANGE Βv Qtv Date Chief Eng / QC Inspector Prod Mar خ.٠٠ Part No: ______ PAR #: ____ Fault Category: _____ NCR: Yes No DQA: ___ Date: ___ Resolution: _____ Disposition: ____ QA: N/C Closed: ____ Date: ____ WORK ORDER NON-CONFORMANCE (NCR) NCR: **Corrective Action** Section B **Description of NC** Verification **Approval Approval** DATE **STEP Action Description** Sian & Initial Section A Section C Chief Eng QC Inspector Chief Eng Chief Eng Date

Work Order ID 53967

Page 3

November 24, 2009 11:15:40 AM

Α

Item ID:

D2873-045

Accept

Setup Start



Stop

Item Name: Start Date:

Revision ID:

25/11/2009

Nut Plate Assembly

Start Otv: 20,00

Rea'd Otv: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



Required Date: 07/12/2009

Date:

SPC (Y/N):

0.00

Date:

Stop

Sequence ID/ Work Center ID

160

HandFinish

Hand Finishing

Operation Description

Chemical Conversion Coat per OSI005 4.1

Set Up/ Run Hours

Number

Draw

Plan Draw Code Rev.

Accept Qty

Reject Oty

Reject Insp. Stamp Number

04/12/01

170

OC

Quality Control

OC3- Inspect Part Finish

Memo

Memo

0.00 ph on 12-1

180

Small Fab Small Fab

Small Fab

Memo

0.00

0.00

Dart Ae	•							ł
W/O:			WC	ORK ORDER CHANGES	}			
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
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Part No):	PAR #:	Fault Cate	gory: I	NCR: Yes	No DQA:	Date: _	
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NCR:			WORK ORD	ER NON-CONFORMAN	CE (NCR)		i
								
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DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section 8 Action Description Chief Eng	Sign &	Verification Section C	Approval Chief Eng	Approva QC Inspecto
DATE	STEP	Description of NC Section A	Initial	Action Description	Sign &			
DATE	STEP	Description of NC Section A	Initial	Action Description	Sign &			
DATE	STEP	Description of NC Section A	Initial	Action Description	Sign &			
DATE	STEP	Description of NC Section A	Initial	Action Description	Sign &			
DATE	STEP	Description of NC Section A	Initial	Action Description	Sign &		Chief Eng	
DATE	STEP	Description of NC Section A	Initial	Action Description	Sign &		Chief Eng	

Work Order ID 53967



Page 4

November 24, 2009 11:15:40 AM

Α

Required Date: 07/12/2009

Item ID:

D2873-045

Accept

Setup Start

Stop



Revision ID: Item Name:

Nut Plate Assembly

Start Date:

25/11/2009

Start Oty: 20:00

Reg'd Otv: 20.00



Cust Item ID:

Customer:

Draw

Reference:

Approvals:

Process Plan:

Date:

Tooling:

2) 201/12/01

Date:

Start Run



SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

190

QC

Quality Control

Operation Description

OC5- Inspect part completeness to step on W/O

Date:

Set Up/ Run Hours

Number

Draw Plan Code Rev.

Accept Oty

Reject Oty

Reject Insp. Stamp Number

courtes

200

Packaging Packaging

Identify as per dwg & Stock Location: X-Tubes

Memo

Memo

0.00

0.00

210

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Dart Aerospace Ltd

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W/O:			WO	RK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Categ	ory:	NCF	R: Yes I	No DQ	4:	Date:	
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NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC	Corrective Action Sec			ection B		ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
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Picklist Print

November 24, 2009 11:15:46 AM

Work Order ID: 53967

Parent Item:

D2873-045RevA

Parent Item Name: Nut Plate Assembly

Comments:



Start Date: 25/11/2009

Required Date: 07/12/2009

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	- 1	Date Issued	Status
MS21075L5		Purchased	No			100	Each	410.0000	40.0000	<i>f</i>	59	/12/	61
				Wareho	<u>use</u>	Loc	<u>Oty</u>	Loc Code					
				Loca	<u>ation</u>								
				Main Wa	arehouse								
				ST			410				_		
					110916		79				_		
					112243		331			40	_		
M6061T6B0.375X01.00		Purchased	No			180	f	17.6095	4.7368				

6061T6 BAR .375 x 1.00

Loc Code Warehouse Loc Qty Location Main Warehouse MAT 17.60947368 105225 5.3 110829 12.3094737

U.7368 and 09/11/27

Dart Aerospace Ltd

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W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHA	NGE	В	y	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				1000						
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: \	'es N	lo DQ	A:	Date:	
		esolution:								
NCR:		\	WORK ORD	ER NON-CONFORMA	ANCE (N	ICR)				
DATE	CTED	Description of NC	Corrective Action Section	ion B		Verific	ation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & late	Secti		Chief Eng	QC Inspector
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Picklist Print

November 24, 2009 11:15:46 AM

Work Order ID: 53967

Parent Item:

D2873-045RevA

Parent Item Name: Nut Plate Assembly

Comments:



Start Date: 25/11/2009

Required Date: 07/12/2009

Page 2

Status

Start Qty: 20.00

Required Qty: 20.00

Date:

Issued

_	Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty
	tem Name	Item ID	Purch	Item	Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued
_ N	1S20426AD4-6		Purchased	No			180	Each	3,930.000	80.0000	



Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	3930		
100151	27		
103395	14		
105144	88		
110139	3774		<u>80</u>
2525	27		

Dart Aerospace Ltd

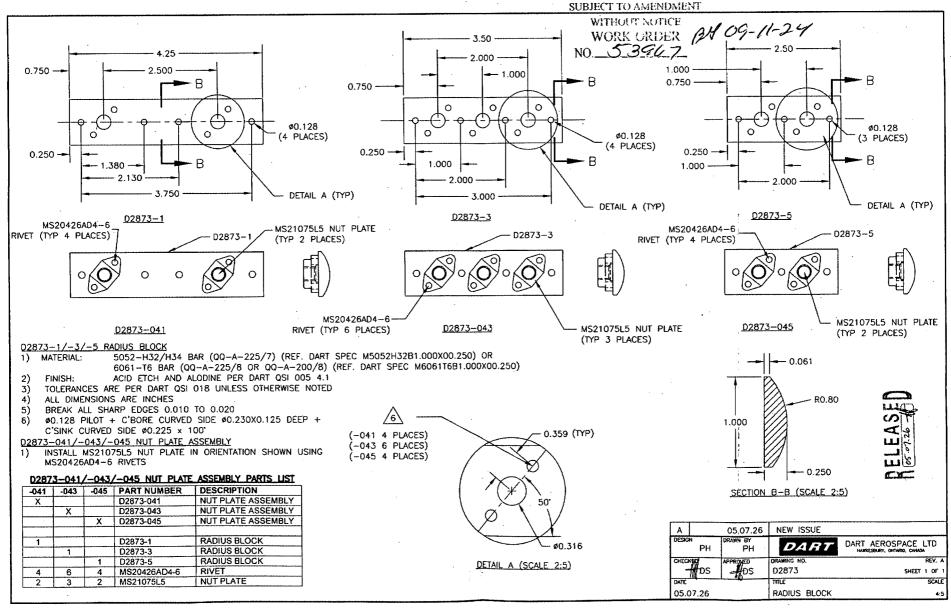
W/O:			WC	ORK ORDER CHANG	BES					
DATE	STEP	PR	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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11.800				·						
	-									
Part No	•	PAR #:	Fault Cate	gory:	NCF	R: Yes I	lo DQ	A :	Date:	
	R	esolution:	Disposition	n:	QA:	N/C Clo	sed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC Corrective Action			Section B Ve			ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	ption Sign & Date			Section C Chief E		QC Inspector
		_								
		·								
				,						

DART AEROSPACE LTD	Work Order:	53947
Description: Radius Block	Part Number:	D2873-5
Inspection Dwg: D2873 Rev: A		Page 1 of 1

	FIRST ART	TCLE INSPE	CTION C	HECKLI	ST	
	X Fi	rst Article	Pr	ototype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2,503				
1.000	+/-0.010	0.997	Ž.			
0.750	+/-0.010	0,750				
0.250	+/-0.010	0,250	\ ,			
1.000	+/-0.010	1.000	\ .			•
2.000	+/-0.010	2,000				
Ø0.128	+0.005/-0.001	0,132		٤		
0.359	+/-0.010	0.359	\			_
Ø0.316	+0.006/-0.001	0,319	$\sqrt{}$			
1.000	+/-0.010	0.997				· · · · · · · · · · · · · · · · · · ·
0.250	+/-0.010	0.250	/			
0.061	+/-0.010	0.067	/ ,_			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	0,230 xa125				
Measured by:	Audi	ted by:	<u> </u>	Proto	type Approval:	N/A
Date:	09/11/28	Date:	129	·	Date:	N/A
		-200 [0-1] [1]	01			
Rev Date	Change	, ·			Revised b	y Approved

	Date:	09/11/28	Date:	1/11/29		Date:	N/A
		To:				Davined by	Annroyed
Rev	Date_	Change			 	Revised by	
A	06.08.30	New Issue	P/O D2873-045			KJ/JLM 🚓	1_ <i>\(\(\(\(\(\) \)</i> \)
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